

Date: Tuesday, 7/11/2006 1:05:44 PM
User: Kim Johnston

Process Sheet

SP67
06-07-13

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 27867A-2
Estimate Number : 10452
P.O. Number :
This Issue : 7/11/2006 S.O. No. :
Prsht Rev. : NC
First Issue : 1/1 Type : SMALL / MED FAB
Previous Run : 27593A
Drawing Name : SUPPORT
Part Number : D32781
Drawing Number : D3278 REV. B
Project Number : N/A
Drawing Revision : B
Material :
Due Date : 7/30/2006 Qty: 40 Um: Each
Written By :
Checked & Approved By : JA 06.07.11
Comment : Est:A 04.04.19 New Issue KJ/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6B1000X02000

6061-T6 Bar 1.0" x 2.0"



Comment: Qty.: 0.4572 f(s)/Unit Total: 18.2868 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick
(M6061T6B1.000x02.000)

Batch:

M101000 / 17 PCS M18745 / 2 PCS 42
M15949 / 21 PCS J.F. 06/07/11

M19059 / 2 PCS

2.0

SHEAR

SHEAR



Comment: SHEAR

Cut blank: 2.00" x 1.00" x 2.550" long

J.F. 06/07/11 42

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-1

SA / J.F. 06/07/11 42

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA / J.F. 06/07/12 42

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Scrup

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/07/12	3	1 piece that is too thin Not set well in the vise. 1 piece that the holes are .1100" off. Didn't take the origine at the right place.		2 parts scrap. destroy. <u>No replace</u>	J.F. 06/07/12			
06/09/12	30	10 parts too thin. Parts were not set well in the vise, and the part kept pulling up. R.C. the parts not held by slot in the vise		Scrap. destroy. <u>No replace.</u>	SAN 06/09/12			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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er:

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 27867A

Part Number: D32781

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W 07.09.05